

ASAP

Date: Tuesday, 03/04/2007 3:20:23 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PIN
Job Number : 31578	
Estimate Number : 12672	
P.O. Number : <i>N/A</i>	Part Number : D31471
This Issue : 03/04/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3147 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 30824	Material : <i>N/A</i>
Written By : _____	Due Date : 10/04/2007
Checked & Approved By : <i>W</i>	Qty: <i>7</i> Um: Each
Comment : Est Rev A New Issue 07-01-26 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0187	303 Round Bar 0.187"
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Comment: Qty.: 0.2363 f(s)/Unit Total: 0.9450 f(s)
303 Round Bar 0.187"
Batch: *M103435*

S.P. 07/04/04

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA113 & DWG D3147,
FOLIO REV: _____ } *new prog.*
DWG REV: _____ }
2-DEBURR AS REQUIRED

J.F. / S.P. 07/04/04

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/04/05

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Drill & mill as per Dwg D3147

J.F. 07/04/05 (9)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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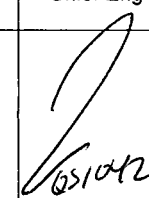

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/04/05 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 07/04/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/05	4	one hole is not center.	 J.F.	Scrap, no replace	J.F. 07/04/05	 07/04/05	 07/04/05	 07/04/05

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN

Job Number: 31578

Part Number: D31471

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 07/04/05

9

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1 Pin to B31168

8 Pin in stock CA

mul 07/04/09

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

⑨

07/04/11

Job Completion



U 07-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

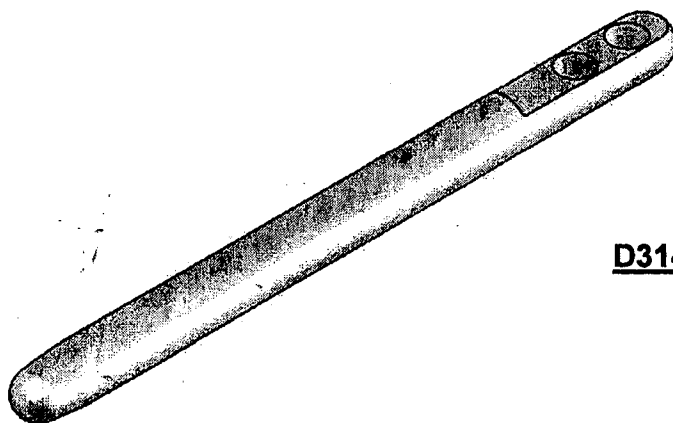
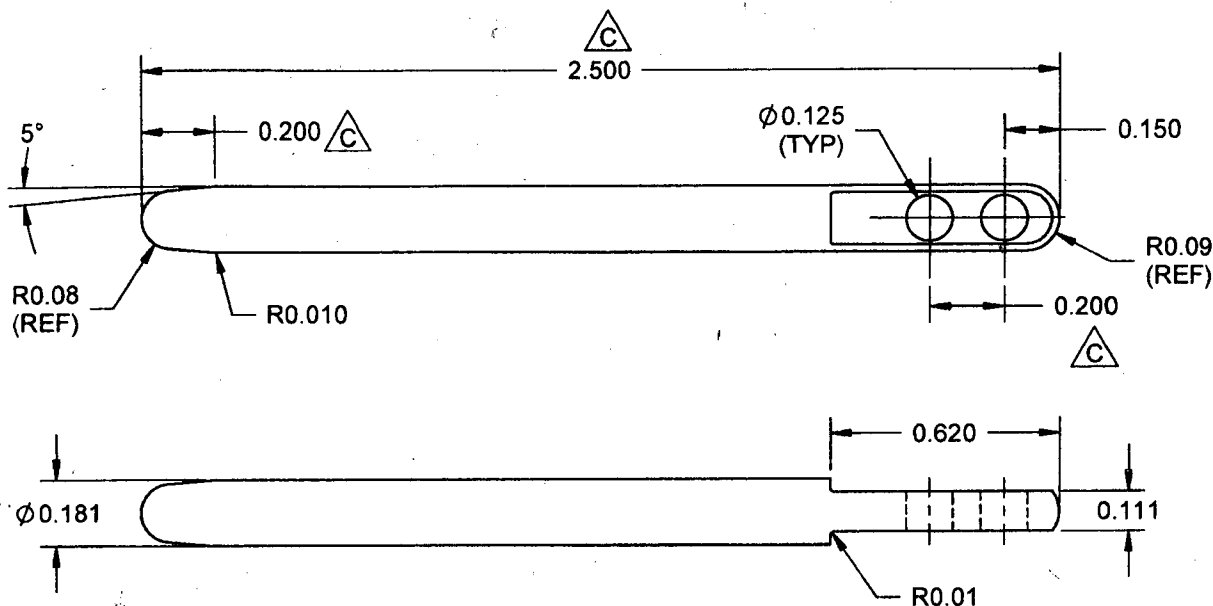
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED JH	DRAWING NO. D3147	REV. C SHEET 1 OF 1
DATE 06.12.04		TITLE PIN	SCALE 2:1
REV	DATE	DESCRIPTION	
A	02.04.23	NEW ISSUE	
B	04.10.18	ADD PART MARKING AND NORMALIZED	
C	06.12.04	ADD SECOND $\phi 0.125$ HOLE; CHANGE MATERIAL; 0.200 TAPER WAS 0.400; REMOVE SUPPLIER AND FINISHING	



D3147-1 PIN

W/O 31578

RELEASED

07-01-22

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3147-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015 MAX
- 7) REPLACES PREMIER P/N B30-23000-119

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